

Work Order ID 80017***80017***

Page 1

Wednesday, February 08, 2012 3:56:00 PM

Item ID: D4005-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Finishing Strip

Stop ***NS2***

Start Date: 2/9/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *12-02-08* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4005

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*B12-2-10**(14)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

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Required Date: 2/28/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

14 BL 12/2/13.

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

14x 1/11/13 12/2/13

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

12/2/14 14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, February 08, 2012 3:56:00 PM

Item ID: D4005-11 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Finishing Strip
Start Date: 2/9/2012 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 2/28/2012 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

[Handwritten signature] M.C.J 12/02/14

M.C.J 12/02/14
14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 08, 2012 3:55:59 P

Page 1

Work Order ID: 80017

Parent Item: D4005-11

Parent Item Name: Finishing Strip

Start Date: 2/9/2012

Required Date: 2/28/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B 10.05.03 as per
ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	106.7000	0.303	1.2757895		B12-2-10	

Location

Loc Qty

Loc Code

MAT022

106.7

118243

30.7

118523

76

118523

14

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

BEND LINE
REF

2.32
REF

0.032
REF

GRAIN
DIRECTION

14.57

R0.12
TYP

2.79

D4005-11F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.032
OR 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
OR 5052-H32 ALUMINUM SHEET
PER QQ-A-250/8 OR AMS-QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4005	SHEET 13 OF 15
APPROVED		TITLE	SCALE
DE APPR.		RESTRAINT	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

#80017

RELEASED
2010-05-05
AWP

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

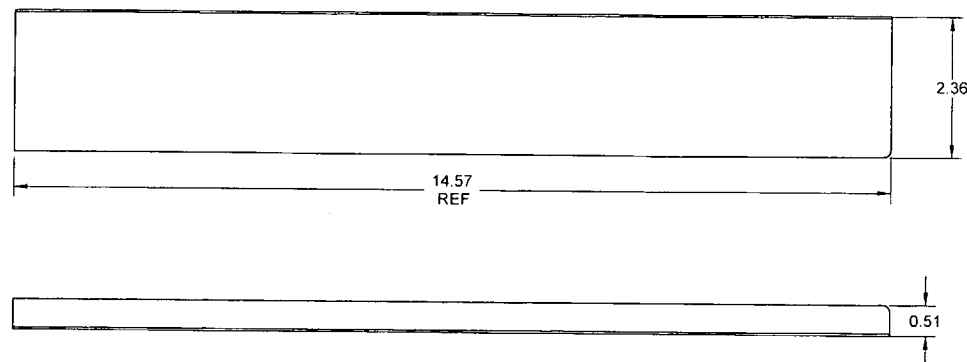
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-11	JCA-M47-2-12



D4005-11 FINISHING STRIP

NOTES:

- 1) MATERIAL: MADE FROM D4005-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4005-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.13 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO.
MFG. APPR.		D4005
APPROVED		TITLE
DE APPR.		RESTRAINT
DATE	10.02.05	REV. A
		SHEET 12 OF 15
		SCALE
		NTS

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RELEASED
2010-05-05

480017

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Dart Aerospace Ltd

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